

Work Order ID 56335



Page 1

February 18, 2010 7:36:45 AM

Item ID: D3689-1

Accept



Setup Start



Revision ID:

Item Name: SLEEVE

Stop



Start Date: 18/02/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 25/02/2010 Req'd Qty: 5.00



Customer:

Reference: Return 2010 / RA11003 / NCR09-111

Approvals:

Process Plan: *JL*

Date:

Tooling:

Date:

Run Start

QC: *JL*Date: *10/02/18*

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3689	Rev B

100 QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

Original B46051. See NCR09-111.
Parts in good condition.

0.00

*S 10/02/18**(X5)*

110



Hardinge

Hardinge CNC Lathe Small

Memo

Re-machine threads as per the drawing. Ensure to be carefull.

0.00

*JL 10/03/03**(S)*

120



QC2- Inspect parts off machine FAI/FAIB

0.00

JL 10/03/03

QC

Quality Control

Memo

Record thread dims on an FAI

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Customer:

Reference: Return 2010 / RA11003 / NCR09-111

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

130



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Draw
Number

Rev.

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

S10103/04

(X5)

140



Outsource2

Outsource process - NDT

Outsource process - NDT per QSI038 4.1

0.00

CZ 10/3/11 (5)

Memo

P/O: 11499

0.00

150



Packaging

Packaging

Receive & Inspect for Damage & Mat'l Certs

0.00

Memo

Attached NDT results

0.00

CZ 10/3/11 5

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Customer:

Reference: Return 2010 / RA11003 / NCR09-111

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC5- Inspect part completeness to step on W/O

Set Up/
Run Hours

0.00

Draw
Number

0.00

Draw
Rev.

0.00

Plan
Code

0.00

Accept
Qty

0.00

Reject
Qty

0.00

Reject
Number

0.00

Insp.
Stamp

S10/03/12

(X)

170



Packaging

Packaging

Identify as per dwg & Stock Location: 82

0.00

10-3-12

(5x) SP

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/03/10 AF

MK

10-3-12

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DART AEROSPACE LTD	Work Order:	56335
Description: Sleeve	Part Number:	D3689-1
Inspection Dwg: D3689	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Refugee Part.

Measured by:	<u>JL</u>	Audited by:	<u>F</u>	Prototype Approval:	N/A
Date:	<u>10/03/03</u>	Date:	<u>10/03/04</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.11	New Issue	KJ	

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8 7 6 5 4 3 2 1

D

C

B

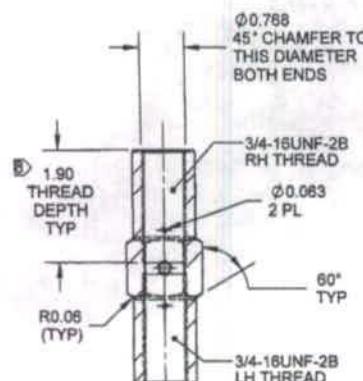
A

D

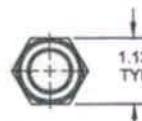
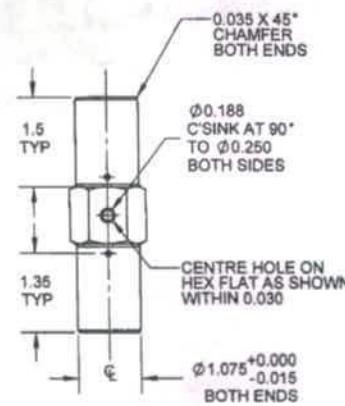
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B

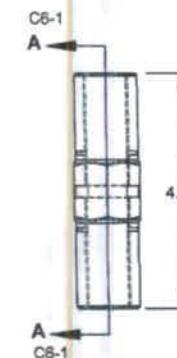
A



SECTION A-A
D3-1



D3689-1 SLEEVE



w/o
56335

RELEASED
08/12/15 MP

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5843 H-900 CONDITION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.67 lb
- 8) DIMENSION SHOWN IS MINIMUM DEPTH OF FULL THREAD
- 9) LPI PER ASTM 1417 LEVEL 2

B	CHANGE TO 17-4PH H-900 (ZN A8-1), REFORMATTED TO CURRENT DWG STANDARDS		RF	08.11.24
A	NEW ISSUE		RF	08.05.22
REV			BY	DATE
DESIGN	RF	DART AEROSPACE LTD		
DRAVN	RF	HAWKESBURY, ONTARIO, CANADA		
CHECKED	SJ	DRAWING NO.	REV. B	
MFG. APPR.	SJ	D3689	SHEET 1 OF 1	
APPROVED	SJ	TITLE	SCALE	N/A
DE APPR.	SJ	SLEEVE		
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LIQUID PENETRANT TEST REPORT

P- 15319

CLIENT	<u>Dart few place</u>	DATE	<u>March 11-2010</u>	PAGE <u>1</u> OF <u>1</u>
ATTENTION	<u>LINDA/CHANTEL</u>	ACUREN JOB NO.	<u>199-10-0709</u>	TIME <input checked="" type="checkbox"/> AM <input type="checkbox"/> PM
ADDRESS	<u>1270 ABERDEEN ST.</u>	PO/WO NO.	<u>-</u>	
PROJECT	<u>HAWKESBURY ON. K0M 1K7</u>	WORK LOCATION	<u>SHOP</u>	
ITEM(S) EXAMINED	<u>F. P. I. ON CROSS TUBES.</u>	ACCEPTANCE STD.	<u>ASTM 1417</u>	REV./DATE <u>2007</u>
	<u>Four cross tubes</u>			

JOB DESCRIPTION	PROCEDURE NO. LT-002 REV./DATE <u>2007</u>	TECHNIQUE NO. LT-T002 REV./DATE <u>2007</u>
PART NO.	<u>STAINLESS STEEL</u>	MATERIAL <u>ALUDINE ALUMINUM</u> THICKNESS <u>-</u>
SCOPE	<u>WET FLUORESCENT LIQUID PENETRANT INSPECTION</u> <u>CARRIED OUT 100% EXTERNAL</u>	

TEST DETAILS					
METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND	<u>MAGNAFLUX</u>				
PENETRANT	<u>ZL G7</u>	MINIMUM DWELL TIME	<u>9520</u> MIN.	BLACK LIGHT S/N <u>16639</u>	<input type="checkbox"/> OUTPUT > 1000 μW/cm ² <input type="checkbox"/> AMBIENT < 2 fc
PENETRANT REMOVER	<u>H2O</u>	MINIMUM DRY TIME	<u>>10</u> MIN.	LIGHTING EQUIP. <input type="checkbox"/> FLASHLIGHT <input type="checkbox"/> TROUBLELIGHT	<input type="checkbox"/> OUTPUT > 100 fc @ SURFACE
DEVELOPER	<u>SILVER</u>	MINIMUM DWELL TIME	<u>10</u> MIN.	OTHER <u>LABVIEW</u>	<input type="checkbox"/> LIGHT METER S/N <u>1098866</u> CAL DUE DATE <u>MT 7-2010</u>
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY		

TEST SURFACE					
SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input checked="" type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/20°F	<input type="checkbox"/> -4°C/20°F TO 10°C/50°F	<input checked="" type="checkbox"/> 10°C/50°F TO 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	

RESULTS- <input type="checkbox"/> METRIC <input type="checkbox"/> IMPERIAL	
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<p>1 CROSS TUBE W.O. 56220 ✓</p> <p>1 CROSS TUBE W.O. 56221 ✓</p> <p>1 CROSS TUBE W.O. 55919 ✓</p> <p>1 CROSS TUBE W.O. 55920 ✓</p> <p>5 SLEEVE'S W.O. 56335 ✓</p> <p>2 Mount's W.O. 56462 ✓</p>	<p>8 10/03/10</p>
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NAME (PRINT):	<u>Mike Johnston</u>		NAME <u></u> INITIALS <u></u>
1 ST TECHNICIAN	<u>#</u>	2 ND TECHNICIAN	
CGSB LEVEL	<u>SNT LEVEL</u>	CGSB LEVEL	<u>SNT LEVEL</u>
CGSB REG. NO.	<u>6600</u>	CGSB REG. NO.	

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